

Work Order ID 145334

Thursday, May 05, 2016 1:34:54 PM

145334

Page 1

Item ID: D119-796-251

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: AFT Crosstube Installation with Step (no hardware)

Stop *NS2*

Start Date: 5/23/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/27/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAY 06 2016 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D119-796-251	D

110	Document Control	0.00							
110									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D119-796-251 chg 002								

Label **DAS 21 9-89** JUL 19 2016

120	Pick Kit	0.00							
120									
Packaging	Memo	0.00							
Packaging									

DAS 41 9-89

16-7-15

130	Crosstubes	0.00							
130									
Crosstubes	Memo	0.46							
Crosstubes	1- Install step and clamp with the proper position per dwg D119-796-251								

DAS 41 9-89

16-7-15

Torque all clamps to 50 IN-LBS max.

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Required Date: 5/27/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89
140									
QC	Memo	0.02							
Quality Control	***RE-CHECK TORQUE ON CLAMP AS PER DWG.***								
	***VERIFY BY <u>38</u> BATCH # TO MATCH W/O								
	<u>145334</u>								
	***VERIFY BY <u>38</u> PART # TO MATCH								
	W/O <u>145334</u>								
150		0.00							DAS 41 9-89
150	Packaging					1			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-251								16-7-15
	For final assembly								
160	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89
160									JUL 19 2016
QC	Memo	0.10							
Quality Control									

SH 7/18/16

Picklist Print

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Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 5/23/2016

Required Date: 5/27/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B
14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19
AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER
REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D
JLM VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-241		Manufactured	No				Each	0.0000		1	DAS 41 9-89	16-7-6	
D119-796-241					146580				**				
AFT Crosstube Installation without Step (no hardware)													
D5123-3		Manufactured	No				Each	64.0000		4	DAS 41 9-89	16-7-6	
D5123-3					145850				**				
Clamp Cushion					144626					4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				LG055			64						
					141331		8						
					144626		56						
D5149-043		Manufactured	No				Each	6.0000		2	DAS 41 9-89	16-7-15	
D5149-043					145835				**				
Aft Step-Base Assembly										2			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				LG055			6						
					142591		6						

Picklist Print

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Parent Item: D119-796-251

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Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 5/23/2016

Required Date: 5/27/2016

Start Qty: 1.00

Required Qty: 1.00

MS21920-25

Purchased

No

Each

32.0000

4

DAS

MS21920-25

41

16-7-6

Clamp

~~9-89~~

Location

Loc Qty

Loc Code

FG

10

120920

10

LG050

14

m134588

14

LG057

8

m134507

8

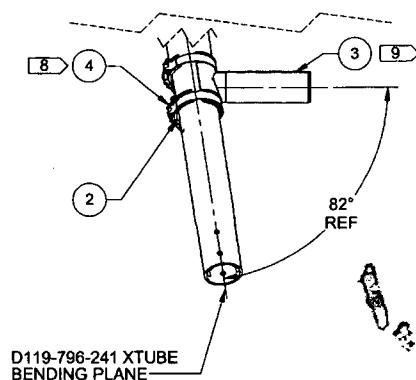
18
4 -> 1 scrap

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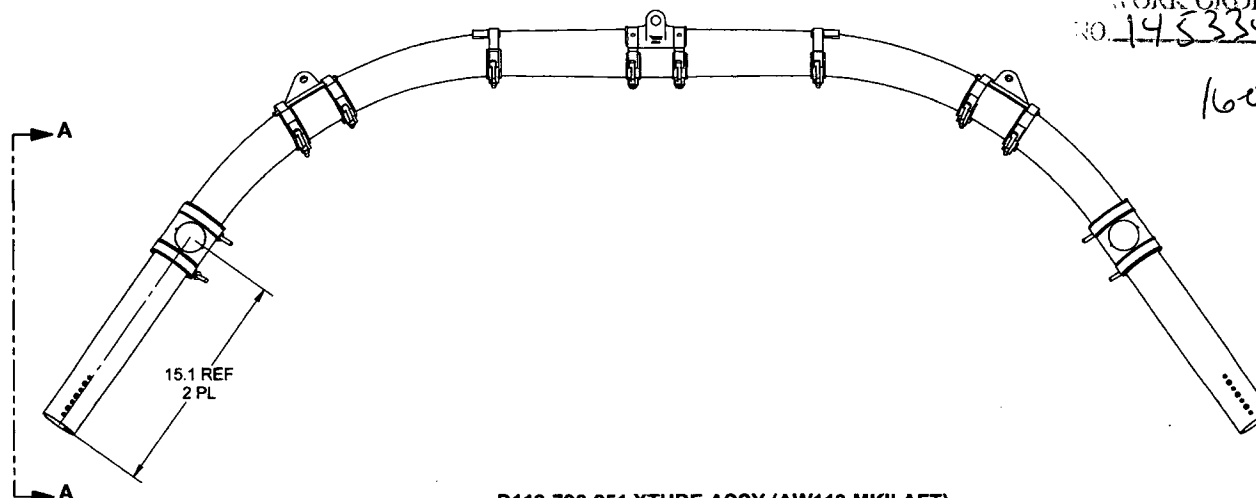
Shop Packet Print

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ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP



SECTION A-A



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

RELEASED

2015 FEB 09

ECN 15-S16

D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	DD	D119-796-251	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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16-05-06